


Date: Wednesday, 2/20/2008 11:23:43 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT ASSEMBLY
Job Number :	37505		
Estimate Number :	10808		
P.O. Number :		Part Number :	D3180041
This Issue :	2/20/2008	Drawing Number :	D3180 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	32710	Material :	
Written By :		Due Date :	2/20/2008
Checked & Approved By :		Qty:	2
Comment :	Est Rev:A 03.01.27 New issue KJ/RF Est Rev:B 07-06-28 Asper Rev B JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 3.7625 f(s)/Unit Total : 7.5249 f(s) *0.065" 4/10/08.0220*
 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall
 (M304TR0.750W0.049)
 Batch: *11104565*

FF 08-02-21 (2)

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313
 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180

FF 08-02-21 (2)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.203" as per Dwg D3180
 2-Bend one side only as per Dwg D3180 Identify as D3180-1
 3-Deburr edges

FF 08-02-21 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP*08-02-21 (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 11:23:43 AM
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Process Sheet

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



M107005



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FF 08-02-21 (X2)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/02/21 (2X)

7.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2022-101 Spacer B 33985

FF 08-02-22 (2)

8.0

D26906

Lanyard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2690-6 Lanyard B 35601

FF 08-02-22 (2)

9.0

A1449

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3180-1(ref) Strut 37505

1 A1449 Grommet M1487

FF 08-02-22 (2)

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer 106167

FF 08-02-22 (2)

~~3011~~ ~~Flash~~

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3180041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

BLRS001

Pip Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 BLRS-001 Pip Pin 17104700

FF 08-02-22

(2)

12.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) 17106242

FF 08-02-22

(2)

13.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-10 Screw 1718036

FF 08-02-22

(2)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3180

FF 08-02-22

(2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/02/22

(2)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 271

8/21

50

(2x)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



08.02.21
KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

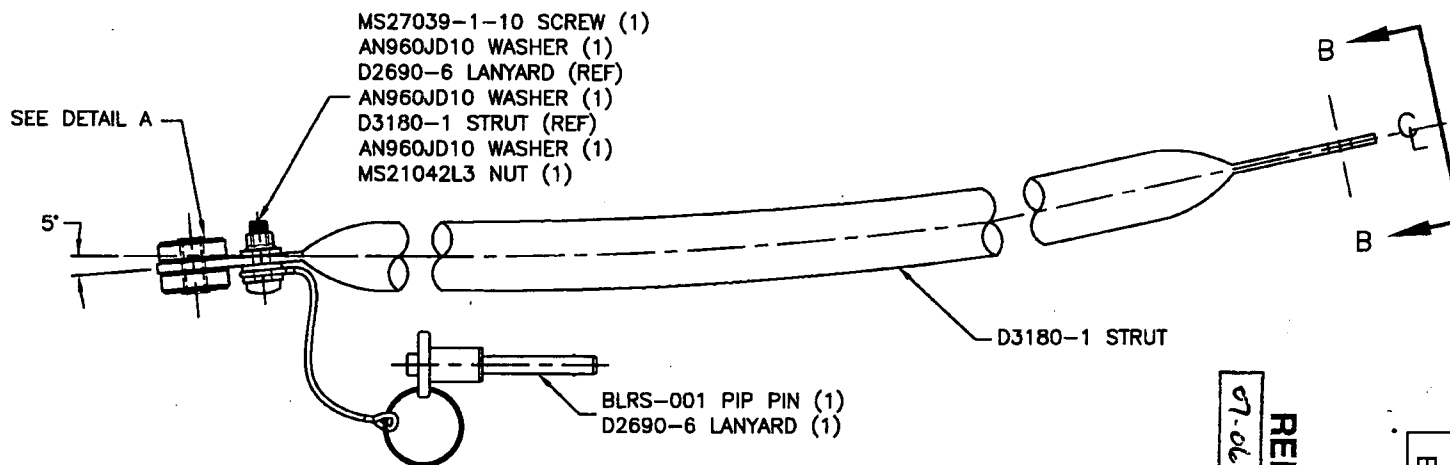


0208102121

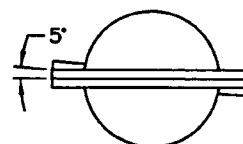
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
4	SE	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
CE	SE	D3180	SHEET 1 OF 2
DATE	TITLE	SCALE	
07.05.23	STRUT ASSEMBLY	1:2	
A	03.01.06	NEW ISSUE	
B	07.05.23	CURVE ADDED	

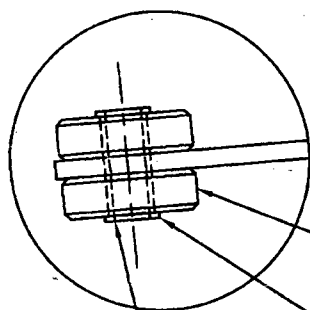
RELEASED
01-06-08



D3180-041 STRUT ASSEMBLY



VIEW B-B
SCALE 1:1



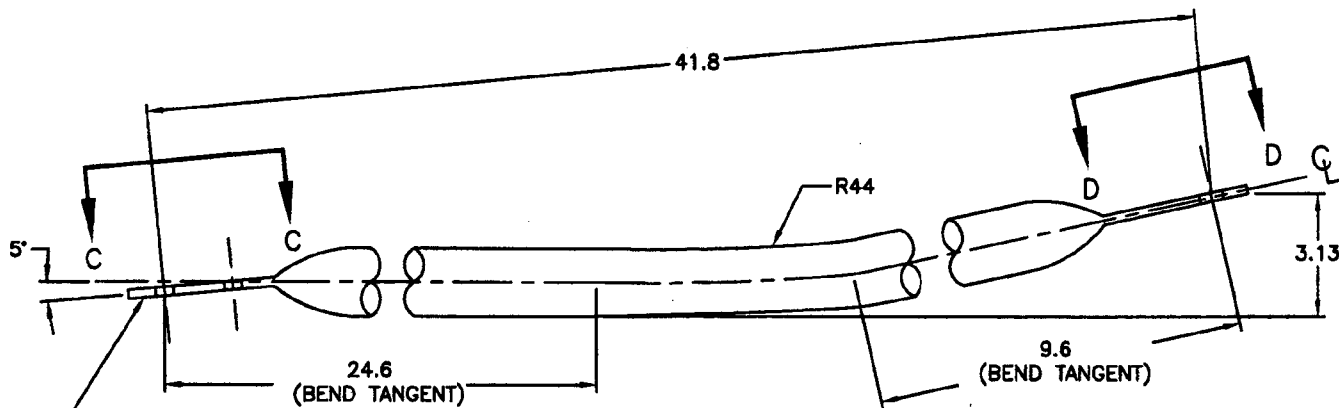
DETAIL A
SCALE 1:1

QTY	PART NUMBER	DESCRIPTION
-041-		
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET

2808/02/20
210.37505

DART

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
DATE	07.05.23			D3180	SHEET 2 OF 2
				TITLE	SCALE
				STRUT ASSEMBLY	1:2



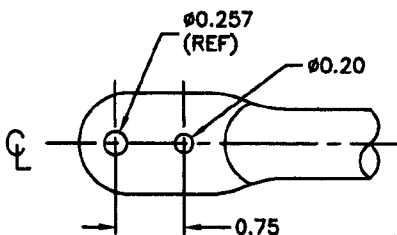
D3180-1 STRUT

USE PUNCH DT8117
BOTH ENDS
(DIMS PER SPEC. CONTROL DWG D2638)

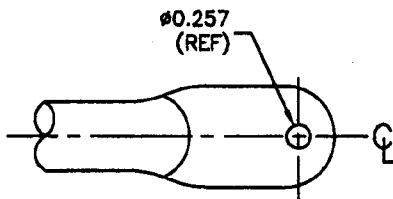
RELEASED
07.06.08

NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
Ø0.75 X 0.065 WALL
(REF. DART SPEC M304TRO.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERMANENT INK MARKER



VIEW C-C



VIEW D-D

WFO
37505
900024